

Work Order ID 130107

February-23-15 1:53:39 PM

130107

~~PRELIMINARY ISSUE~~

Page 1

Item ID: D5085-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: ~~PRELIM~~ Stop *NS2*
 Item Name: Web
 Start Date: 2/23/15 / Start Qty: 6.00 *6* Cust Item ID:
 Required Date: 3/02/15 Req'd Qty: 6.00 *6* Customer:
 Reference:

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D5085	REV. A JUN 22 2015 CZ

100		0.00							
100									
Purchasing		0.00							
Purchasing									
	Memo								
	Purchasing								
	Issue P/O: 28926								
	Supplier: WEJAY								
	Machine as per Dwg D5085								
	Conformity sheet required								

110	Receive & Inspect for Damage & Mat'l Certs	0.00							
110									
Packaging		0.00							
Packaging									
	Memo								

CZ JUN 24 2015 6

Cex Sp 15-08-12

Work Order ID 130107

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Page 2

Item ID: D5085-1
 Revision ID: PRELIM
 Item Name: Web
 Start Date: 2/23/15 Start Qty: 6.00
 Required Date: 3/02/15 Req'd Qty: 6.00
 Reference:

Accept ***N900040100*** Setup Start ***NS1***
 Stop ***NS2***

Cust Item ID:
 Customer:

6
6

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC6- Inspect dimensions to drawing	0.00							
120									DAS
QC	Memo	0.00							9
Quality Control									3-29
130	Chemical Conversion Coat per QSI005 4.1	0.00							
130									
HandFinish	Memo	0.00							
Hand Finishing									
140	QC6- Inspect Part Finish	0.00							
140									
QC	Memo	0.00							
Quality Control									

① 15-08-13

6 0 15-8-17 Dec

6 0 15-8-18

PTG

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: <u>130107</u> Part No. <u>D8085-1</u> NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; font-size: small;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design		15-08-18	140	1	Should Read QC7			15.08.20		
Doc/Data	☒									
Equip/Tooling										
Handling/Pre										
Material										
Operator										
Offset/Setup										
Process										
Supplier										
Training										
Transport										
Unapproved										

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Item ID: D5085-1 Accept *N9000040100* Setup Start *NS1*
 Revision ID: PRELIM Stop *NS2*
 Item Name: Web
 Start Date: 2/23/15 Start Qty: 6.00 *6* Cust Item ID:
 Required Date: 3/02/15 Req'd Qty: 6.00 *6* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <u>4/6</u>	0.00							
150									
Packaging	Memo	0.00				<u>6</u>	<u>0</u>	<u>15-8-18</u>	<u>DBL</u>
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00				<u>MCS</u>		<u>AUG 10 2015</u>	
Quality Control									

~~POSITIVE RECALL~~
 EFFECTIVE 50273 AUTH LL
 RELEASED _____ DATE _____

20150819

5#

Picklist Print

February-23-15 1:53:39 PM

Page 1

Work Order ID: 130107

130107

Parent Item: D5085-1

D5085-1

Parent Item Name: Web

Start Date: 2/23/15

Required Date: 3/02/15

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A NEW ISSUE 14-10-27 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D5085-1P		Purchased	No				Each	0.0000		6			
D5085-1P									**				
Web													
D5086-1-180		Manufactured	No				Each	12.0000		6			

D5086-1-180

Extrusion 180" Long

Location

Loc Qty

Loc Code

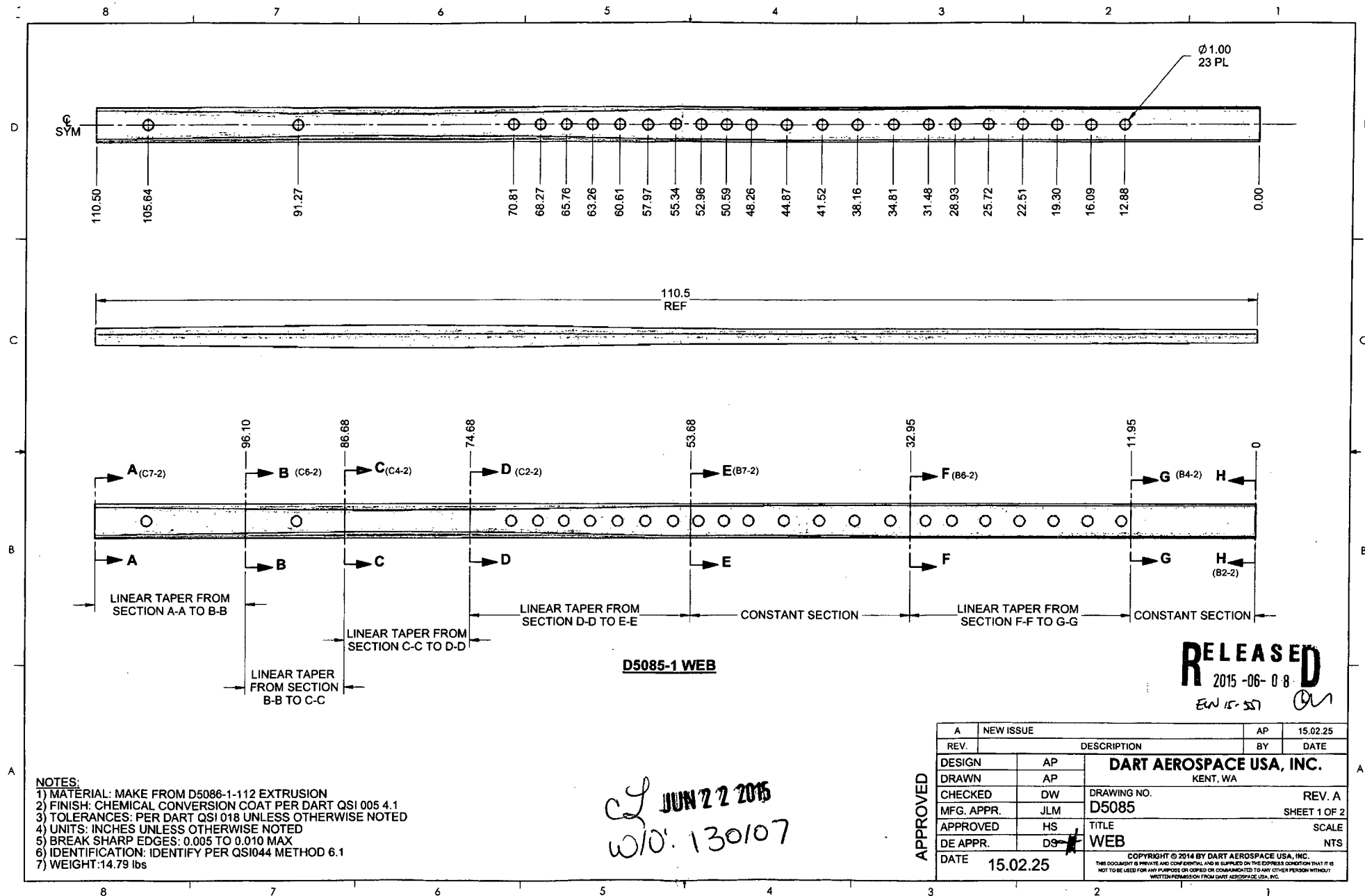
HALL

12

123994

12

6 15-6-23



RELEASED
2015-06-08
EW 15-557

CL JUN 22 2015
W/O: 130107

8

7

6

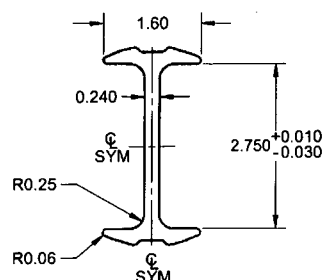
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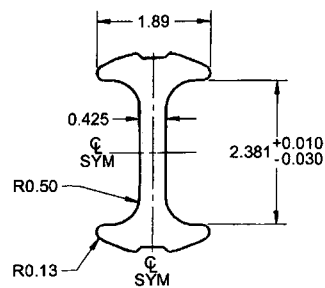
3

2

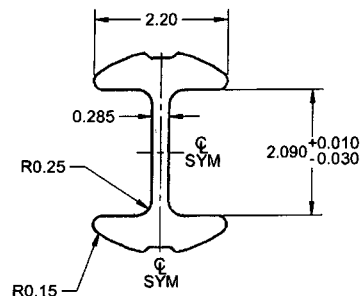
1



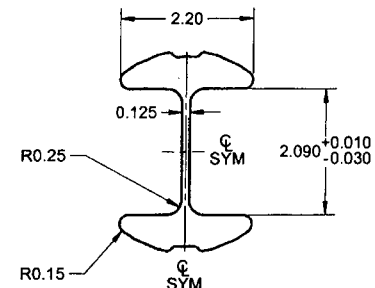
SECTION A-A (B8-1)
SCALE 4X



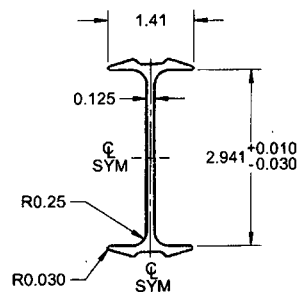
SECTION B-B (B7-1)
SCALE 4X



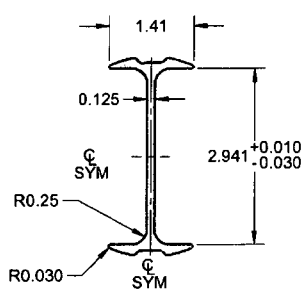
SECTION C-C (B7-1)
SCALE 4X



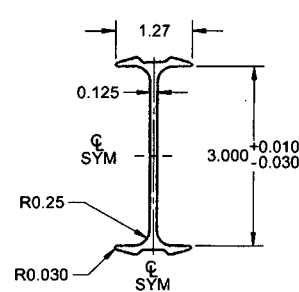
SECTION D-D (B6-1)
SCALE 4X



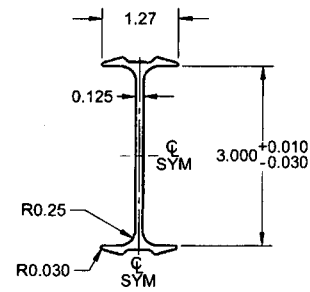
SECTION E-E (B4-1)
SCALE 4X



SECTION F-F (B3-1)
SCALE 4X



SECTION G-G (B2-1)
SCALE 4X



SECTION H-H (B1-1)
SCALE 4X

RELEASED
2015-06-08

APPROVED

DESIGN	AP	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	AP		
CHECKED	DW	DRAWING NO.	REV. A
MFG. APPR.	JLM	D5085	SHEET 2 OF 2
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	WEB	NTS
DATE	15.02.25	COPYRIGHT © 2014 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

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1



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO28926

Purchase Order Date 6/24/2015

PO Print Date 6/24/2015

Page Number 1 of 2

Order From :

VC-WMP001

Ship To : DART AEROSPACE LTD

WEJAY MACHINE PRODUCTS CO. LTD
600 O'CONNOR DRIVE
KINGSTON, ONTARIO K7P 1N3
CANADA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 613-384-1662

Ship To Contact

Ship To Phone

Ship Via: Day & Ross collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Line Nbr	Reference Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
	Line Comments		Promise Date				
	Delivery Comments						

1	D3885-1P	Standard Web	7/27/2015 Yes 7/27/2015		10.00 Each	\$520.00	\$5,200.00
	AS PER DWG D3885 REV. B B133854						

CL15/07/27

Line Total: \$5,200.00

2	D5085-1P	Web	7/27/2015 Yes 7/27/2015	FN	6.00 Each	\$945.00	\$5,670.00
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AS PER DWG D5085 REV. A
B130107

SP15-08-12

Line Total: \$5,670.00

PO Instructions: QUOTATION NO. WJ-8557, WJ-8455

Note:

6/24/2015

NO GOODS RETURNED WITHOUT
PRIOR AUTHORIZATION

(Report all dimensions and features required by drawing)

Drawing Number (Including Revision): D5085-1P REV. A

8/5/12

Date: Aug 6/15



600 O'CONNOR DRIVE
KINGSTON, ONTARIO
K7P 1N3

INSPECTION / TEST REPORT

JOB No. 37433

PAGE: 1 of 3

CUSTOMER: Dart Aerospace

CUST. P.O.# PO28926

PART No. D5085-1

DESCRIPTION: Web

DWG No. D5085 - sheets 1-2

REV. A3

E.C.O. --

MATERIAL: Extrusions supplied by DAS

INSPECTOR:

QUANTITY
REC'D:

ACCEPT:

REJECT:

N.C.R.#

DATE:

INSTRUCTIONS, COMMENTS:

ITEM REF. No.	CHARACTERISTIC	DETAILS	TOLERANCE	DWG SHT/ZONE	RESULT	QTY. INSP.	COMMENTS (ACC. REJ. REW. NMR #)
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1	110.5	O.A. length	±.03	1_C4	OK.	1	Acc
2	Hole, Diameter 1.00	23 places	+0.010/-0.001	1_D1	1.000 - 1.001	1	"
3	12.88		±.03	1_D2	OK.	1	"
4	16.09		±.03	1_D2	OK.	1	"
5	19.30		±.03	1_D2	OK.	1	"
6	22.51		±.03	1_D2	OK.	1	"
7	25.72		±.03	1_D3	OK.	1	"
8	28.93		±.03	1_D3	OK.	1	"
9	31.48		±.03	1_D3	OK.	1	"
10	34.81		±.03	1_D3	OK.	1	"
11	38.16		±.03	1_D3	OK.	1	"
12	41.52		±.03	1_D4	OK.	1	"
13	44.87		±.03	1_D4	OK.	1	"
14	48.26		±.03	1_D4	OK.	1	"
15	50.59		±.03	1_D4	OK.	1	"
16	52.96		±.03	1_D4	OK.	1	"
17	55.34		±.03	1_D5	OK.	1	"
18	57.97		±.03	1_D5	OK.	1	"
19	60.61		±.03	1_D5	OK.	1	"
20	63.26		±.03	1_D5	OK.	1	"
21	65.76		±.03	1_D5	OK.	1	"
22	68.27		±.03	1_D5	OK.	1	"
23	70.81		±.03	1_D6	OK.	1	"
24	91.27		±.03	1_D7	OK.	1	"
25	105.64		±.03	1_D8	OK.	1	"
26	Sym to centerline		±.03	1_D8	OK.	1	"

SECTION A-A

27	110.5	Loc'n of section	±.03	1_C7	OK.	1	"
28	2.750	2 pl.	+0.010/-0.030	2_D7	2.746 - 2.748	1	"
29	R 0.25	4 pl.	±.03	2_D8	R.25 TYP	1	"

INSPECTION / TEST REPORT						JOB No. 37433 PAGE: 2 of 3	
CUSTOMER: Dart Aerospace							
CUST. P.O. PO28926							
PART No. D5085-1				DESCRIPTION: Web			
DWG No. D5085 - sheets 1-2				REV. A3		E.C.O. --	
REF. No.	CHARACTERISTIC	DETAILS	TOLERANCE	DWG SHT/ZONE	RESULT	QTY. INSP.	COMMENTS (ACC. REJ. REW. NMR #)

30	1.60	2 pl.	±.03	2_D7	1.602-1.604	1	Acc.
31	.240		±.01	2_D8	.231-.232	1	"
32	R .06	4 pl.	±.03	2_C8	R.06 TYP.	1	"

SECTION B-B

33	96.10	Loc'n of section	±.03	1_C7	O.K.	1	Acc.
34	2.381	2 pl.	+0.010/-0.030	2_D5	2.381-2.382	1	"
35	R 0.50	4 pl.	±.03	2_D6	R.50 TYP.	1	"
36	1.89	2 pl.	±.03	2_D6	1.886-1.887	1	"
37	.425		±.01	2_D6	.417	1	"
38	R .13	4 pl.	±.03	2_D6	R.13 TYP.	1	"
39	Linear taper	Sect. A-A to B-B	-	1_B8	O.K.	1	"

SECTION C-C

40	86.68	Loc'n of section	±.03	1_C6	O.K.	1	Acc.
41	2.090	2 pl.	+0.010/-0.030	2_D3	2.084-2.094	1	"
42	R 0.25	4 pl.	±.03	2_D4	R.25 TYP.	1	"
43	2.20	2 pl.	±.03	2_D4	2.175-2.180	1	"
44	.285		±.01	2_D4	.280	1	"
45	R .15	4 pl.	±.03	2_C4	R.15 TYP.	1	"
46	Linear taper	Sect. B-B to C-C	-	1_B7	O.K.	1	"

SECTION D-D

47	74.68	Loc'n of section	±.03	1_C6	O.K.	1	Acc.
48	2.090	2 pl.	+0.010/-0.030	2_D1	2.084-2.087	1	"
49	R 0.25	4 pl.	±.03	2_D2	R.25 TYP.	1	"
50	2.20	2 pl.	±.03	2_D2	2.184-2.186	1	"
51	.125		±.01	2_D2	.129	1	"
52	R .15	4 pl.	±.03	2_C2	R.15 TYP.	1	"
53	Linear taper	Sect. C-C to D-D	-	1_B6	O.K.	1	"

SECTION E-E

54	53.68	Loc'n of section	±.03	1_C5	O.K.	1	Acc.
55	2.941	2 pl.	+0.010/-0.030	2_B7	2.934-2.942	1	"
56	R 0.25	4 pl.	±.03	2_B8	R.25 TYP.	1	"
57	1.41	2 pl.	±.03	2_C7	1.389-1.391	1	"
58	.125		±.01	2_B8	.127	1	"
59	R .030	4 pl.	±.01	2_B8	R.030 TYP.	1	"
60	Linear taper	Sect. D-D to E-E	-	1_B5	O.K.	1	"

INSPECTION / TEST REPORT

JOB No. 37433

PAGE: 3 of 3

CUSTOMER: Dart Aerospace

CUST. P.O. PO28926

PART No. D5085-1

DESCRIPTION: Web

DWG No. D5085 - sheets 1-2

REV. A3

E.C.O. --

REF. No.	CHARACTERISTIC	DETAILS	TOLERANCE	DWG SHT/ZONE	RESULT	QTY. INSP.	COMMENTS (ACC. REJ. REW. NMR #)
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SECTION F-F

43	32.95	Loc'n of section	±.03	1_C3	O.K.	1	Acc.
44	2.941	2 pl.	+ .010/- .030	2_B5	2.936-2.942	1	"
45	R 0.25	4 pl.	±.03	2_B6	R.25 TYP.	1	"
46	1.41	2 pl.	±.03	2_C6	1.392-1.393	1	"
47	.125		±.01	2_B6	.124	1	"
48	R .030	4 pl.	±.01	2_B6	R.03 TYP.	1	"
49	Constant Section	Sect. E-E to F-F	-	1_B4	O.K.	1	"

SECTION G-G

50	11.95	Loc'n of section	±.03	1_C2	O.K.	1	Acc.
51	3.000	2 pl.	+ .010/- .030	2_B3	2.996-3.001	1	"
52	R 0.25	4 pl.	±.03	2_B4	R.25 TYP.	1	"
53	1.27	2 pl.	±.03	2_C4	1.245-1.250	1	"
54	.125		±.01	2_B4	.121	1	"
55	R .030	4 pl.	±.01	2_B4	R.03 TYP.	1	"
56	Linear taper	Sect. F-F to G-G	-	1_B3	O.K.	1	"

SECTION H-H

57	0.00	Loc'n of section	±.03	1_C1	O.K.	1	Acc.
58	3.000	2 pl.	+ .010/- .030	2_B1	2.998-3.001	1	"
59	R 0.25	4 pl.	±.03	2_B2	R.25 TYP.	1	"
60	1.27	2 pl.	±.03	2_C2	1.250-1.256	1	"
61	.125		±.01	2_B2	.121-.124	1	"
62	R .030	4 pl.	±.01	2_B2	R.03 TYP.	1	"
63	Constant Section	Sect. G-G to H-H	-	1_B1	O.K.	1	"